

Work Order ID 149913

August 10, 2016 2:00:45 PM

149913

*Stock but need sales
Stock Oct 1 for to ship Sept 9th.*

Item ID: D350-591-311

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible

Stop

NS2

Start Date: 8/10/2016 Start Qty: 4.00

4

Cust Item ID:

Required Date: 8/31/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: *SHA* Date: **AUG 08 2016**

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3272	Rev B

100

Document Control

0.00

100

DC

DOCUMENT CONTROL

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and type labels as per PPP D350-591-311 CHG001Z

NON-AIRBUS

Smb
SEP 09 2016

**DAS
21
9-99**

16-05-08
(Signature)

110

Large Fab

0.00

110

Large Fab

Memo

0.21

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per OSI 004 & Dwg D3272

A/RAluminum Rod *134826*

3-Grind End Plate flush

4

AUG 31 2016

**DAS
24
9-99**

B#149913 4xLH

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

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OTHER :																																																																							

August 10, 2016 2:00:45 PM

Page 2

Accept

Setup Start *NS1*

NS1

Stop *NS2*

Cust Item ID:

Customer:

Run Start *NR1*

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00

QC

Memo

0.00

Quality Control

④ 16.09.02

DAS
9
9-89

130

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

QC

Quality Control

④ 1659.52

DAS
9
9-89

140

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.13

HandFinish

Hand Finishing



 2016/09/06
 BEB

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
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Work Order ID 149913***149913***

Page 3

August 10, 2016 2:00:45 PM

Item ID: D350-591-311

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 8/10/2016 Start Qty: 4.00

4

Cust Item ID:

Required Date: 8/31/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC7-Inspect Chemical Conversion Coat	0.00				4			
150							SEP 07 2016		DAS 24 9-06
QC	Memo	0.01							
Quality Control									

180

0.00

180

Large Fab

Large Fab

Large Fab

Memo

0.19

1-Assemble Leg Assembly as per Dwg D3272.

2-Leave one rivet out until welding is complete.

3-Bevel Aft end for welding

4-Inspect for foreign object as per QSI 024

5-Weld Aft End Plate as per QSI 004 & Dwg D3272
A/RAluminum Rod 134826

6-Grind End Plate flush

7-Install last rivet as per Dwg.

DAS
24
9-06

4 SEP 07 2016 16-09-07

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																																																																						
Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐																																																																						
Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐																																																																						
Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																																																																						
Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																																																																						
Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																																																																						
OTHER :																																																																									

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

Work Order ID 149913

August 10, 2016 2:00:45 PM

149913

Page 5

Item ID: D350-591-311 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible
 Start Date: 8/10/2016 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 8/31/2016 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	White Gloss(Ref:4.3.5.1) per OSI005 4.3-Alum	0.00							
220	<i>M 135418</i>					<i>4</i>	<i>0.1609-8</i>	<i>DAS 34 9-89</i>	
Powdercoat	Memo	0.11							
Powder Coating	START TIME: <i>7:55</i> OVEN TEMPERATURE: <i>320°</i> FINISH TIME: <i>9:20</i>								
230	Wing Walk as per dwg OSI005 4.4 Batch <i>1135317</i>	0.00							
230									
HandFinish	Memo	0.13							
Hand Finishing									<i>2016/09/08</i> <i>BEB</i>
240	QC3- Inspect Part Finish	0.00							
240									
QC	Memo	0.01							<i>DAS 38 9-89</i>
Quality Control						<i>(4)</i>			<i>SEP 09 2016</i>

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause		FAULT CATEGORY																							
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OTHER :																									

Work Order ID 149913

August 10, 2016 2:00:45 PM

149913

Page 6

Item ID: D350-591-311 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible
 Start Date: 8/10/2016 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 8/31/2016 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	Pick Kit	0.00							
250									
Packaging	Memo	0.01							
Packaging									
260	QC4- 100% Inspect kits for completeness	0.00							
260									
QC	Memo	0.02							
Quality Control									
270	Packaging	0.00							
270									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD350-591-311								
	Location : FG084								

(4) PC DAS 6 9-89
 9102 6 0 SEP 09 2016

SMB
 SEP 10 2016

DAS 27 9-89
 SEP 09 2016

1x 3x sold 1x lg 080

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
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Root Cause		FAULT CATEGORY																							
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OTHER :																									

Work Order ID 149913***149913***

Page 7

August 10, 2016 2:00:45 PM

Item ID: D350-591-311

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 8/10/2016 Start Qty: 4.00

4

Cust Item ID:

Required Date: 8/31/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280	QC21 - Final Inspection - Work Order Release	0.00					DAS 21 9-89		
280									
QC	Memo	0.07							
Quality Control									

SEP 09 2016

DAS
21
9-89

SEP 09 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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OTHER :																																																																									

Picklist Print

August 10, 2016 2:00:56 PM

Page 1

Work Order ID: 149913

149913

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 8/10/2016

Required Date: 8/31/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A04.03.22New issue KJ/RF
IPP Rev:B 07-06-09 Added D3272-1 JLM
IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC
IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3272-1		Manufactured	No			110	Each	0.0000	1	4			
---------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

✓ ***D3272-1***

Step

** B149914 → 4

D3067-1

Manufactured No

110

Each

83.0000

1

4

✓ ***D3067-1***

End Plate

** AUG 31 2016

Location

Loc Qty

Loc Code

WA003

83

146024

37

149150

46

4

D3219-1

Manufactured No

110

Each

90.0000

2

8

✓ ***D3219-1***

Plate

** AUG 31 2016

Location

Loc Qty

Loc Code

WA003

90

146684

18

149190

72

8

D3066-1

Manufactured No

180

Each

102.0000

2

8

✓ ***D3066-1***

Spacer

** 8 CP 16-08-06

Location

Loc Qty

Loc Code

WA003

102

146706

56

149165

46

B146706 → 4
B149165 → 4

DAS
24
9-88

DAS
24
9-88

DAS
24
9-88

Picklist Print

August 10, 2016 2:00:56 PM

Work Order ID: 149913

149913

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 8/10/2016

Required Date: 8/31/2016

Start Qty: 4.00

Required Qty: 4.00

MS20600-AD4W4

Purchased

No

180

Each

1,398.000

16

64

✓ ***MS20600-AD4W4***

Rivets

****** B133990 64 C 16-09-07

Location

Loc Qty

Loc Code

CCK005

770

M133990

770

ST308

106

M133990

106

WA003

522

M133990

60

M134955

462

D3065-041

Manufactured

No

180

Each

27.0000

1

4

✓ ***D3065-041***

Step Leg Assembly

****** B149087 1x C 16-09-07
B145654 → 3x

Location

Loc Qty

Loc Code

WA002

27

145654

2

149087

25

D3067-1

Manufactured

No

180

Each

83.0000

1

4

✓ ***D3067-1***

End Plate

****** B149150 4x C 16-09-07

Location

Loc Qty

Loc Code

WA003

83

146024

37

149150

46

Picklist Print

August 10, 2016 2:00:56 PM

Work Order ID: 149913

149913

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 8/10/2016

Required Date: 8/31/2016

Start Qty: 4.00

Required Qty: 4.00

AN3-35A

Purchased

No

250

Each

107.0000

2

8

AN3-35A

Bolt

**

PC

DAS
6
9-89LocationLoc QtyLoc Code

FG

10

122800

10

over003

20

m135390

20

ST348

77

m134167

50

m134497

1

m134943

26

8

D3235-1

Manufactured

No

250

Each

236.0000

2

8

D3235-1

Mounting Lug

**

PC

DAS
6
9-89LocationLoc QtyLoc Code

ST521

86

146290

86

ST525A

100

147073

100

ST532A

50

148140

50

8

D3278-041

Manufactured

No

250

Each

62.0000

1

4

D3278-041

Support Assembly

**

PC

DAS
6
9-89LocationLoc QtyLoc Code

ST522

62

145581

2

146685

20

148625

20

149068

20

4

SEP 09 2016

August 10, 2016 2:00:56 PM

Shop Packet Print

Picklist Print

August 10, 2016 2:00:56 PM

Work Order ID: 149913

149913

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 8/10/2016

Required Date: 8/31/2016

Start Qty: 4.00

Required Qty: 4.00

NAS1149D0463J

Purchased

No

250

Each

2,154.000

16

64

NAS1149D0463.J

Washer

**

PC

DAS
6
9-89

Location

Loc Qty

Loc Code

GA	240
M132035	15
M134508	32
M135056	193
ST260a	1600
<u>M135390</u>	1600
ST263	314
M134943	66
M135056	248

64

SMB

NAS1149D0563J

Purchased

No

250

Each

819.0000

4

16

NAS1149D0563.J

Washer

**

PC

DAS
6
9-89

Location

Loc Qty

Loc Code

GA	117
m125807	2
m133769	115
ST263	603
m134497	4
<u>m135058</u>	599
ST269	99
m128257	99

16

SEP 09 2016

DAS
28
9-89

SMB

DS/ 94110 011 4x ISO 876

DAS
27
9-89

Picklist Print

August 10, 2016 2:00:56 PM

Work Order ID: 149913

149913

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 8/10/2016

Required Date: 8/31/2016

Start Qty: 4.00

Required Qty: 4.00

AN5-36A

Purchased

No

250

Each

131.0000

2

8

AN5-36A

Bolt

**

DAS
6
9-89

PC

Location

Loc Qty

Loc Code

over004

100

M135297

100

ST336

31

M130466

15

M134861

16

8

Smf

D2618

Manufactured

No

250

Each

152.0000

2

8

D2618

Bushing

**

DAS
6
9-89

PC

Location

Loc Qty

Loc Code

ST008A

152

146622

5

147525

147

8

D2230-3

Manufactured

No

250

Each

148.0000

4

16

D2230-3

Mounting Lug

**

DAS
6
9-89

PC

Location

Loc Qty

Loc Code

FG

8

109344

4

89045

4

ST521

2

144487

2

ST525A

138

146287

138

16

Smf

SEP 09 2016

Picklist Print

August 10, 2016 2:00:56 PM

Work Order ID: 149913

149913

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 8/10/2016

Required Date: 8/31/2016

Start Qty: 4.00

Required Qty: 4.00

D2856-400-720

Manufactured No

250

Each

103.0000

2

8

D2856-400-720

Abrasion Strip 4" X 7.20"

**

PC

DAS
6
9-89

SEP 09 2016

Location

Loc Qty

Loc Code

FG

17

134509

4

137049

2

146220

11

ST418

86

137049

0

146220

2

149045

84

8

MS21042L3

Purchased

No

250

Each

1,461.000

2

8

MS21042L3

Nut

**

PC

DAS
6
9-89

SEP 09 2016

Location

Loc Qty

Loc Code

FP001

14

m133790

14

GA

535

m134360

112

m135135

423

ST303

912

m134039

12

m135056

200

m135135

700

8

Picklist Print

August 10, 2016 2:00:56 PM

Work Order ID: 149913

149913

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 8/10/2016

Required Date: 8/31/2016

Start Qty: 4.00

Required Qty: 4.00

AN4-13A

Purchased

No

250

Each

468.0000

8

32

AN4-13A

Bolt

**

Y32 MBS464 PC

Location

Loc Qty

Loc Code

DA
6
9-88

FG	20
122808	20
GA	19
m134634	19
over003	39
m134943	39
ST343	390
m134852	36
m135390	354

SNP

MS21042L5

Purchased

No

250

Each

432.0000

2

8

MS21042L5

Nut

**

PC

Location

Loc Qty

Loc Code

DAS
6
9-89

GA	67
m127813	67
OVER007	200
m135297	200
ST303	165
m134055	6
m134955	59
<u>m135058</u>	100

SNP

SEP 09 2016

8

Picklist Print

August 10, 2016 2:00:56 PM

Work Order ID: 149913

149913

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 8/10/2016

Required Date: 8/31/2016

Start Qty: 4.00

Required Qty: 4.00

MS21042L4

Purchased

No

250

Each

1,686.000

8

32

MS21042L4

Locknut

**

PK

DAS
6
9-89

Location

Loc Qty

Loc Code

FP001

51

m133363

51

GA

424

m133769

116

m135058

308

ST3003

26

m134955

26

ST303

1185

m135127

209

m135297

976

30

NAS1149D0363J

Purchased

No

250

Each

1,779.000

4

16

NAS1149D0363J

Washer

**

PK

DAS
6
9-89

Location

Loc Qty

Loc Code

GA

386

m134055

386

ST263

1393

m134955

393

m135297

1000

ko

SEP 09 2016

DART

DESIGN <i>9P</i>	DRAWN BY <i>JB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>JB</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED*07.06.04*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

AUG 08 2016

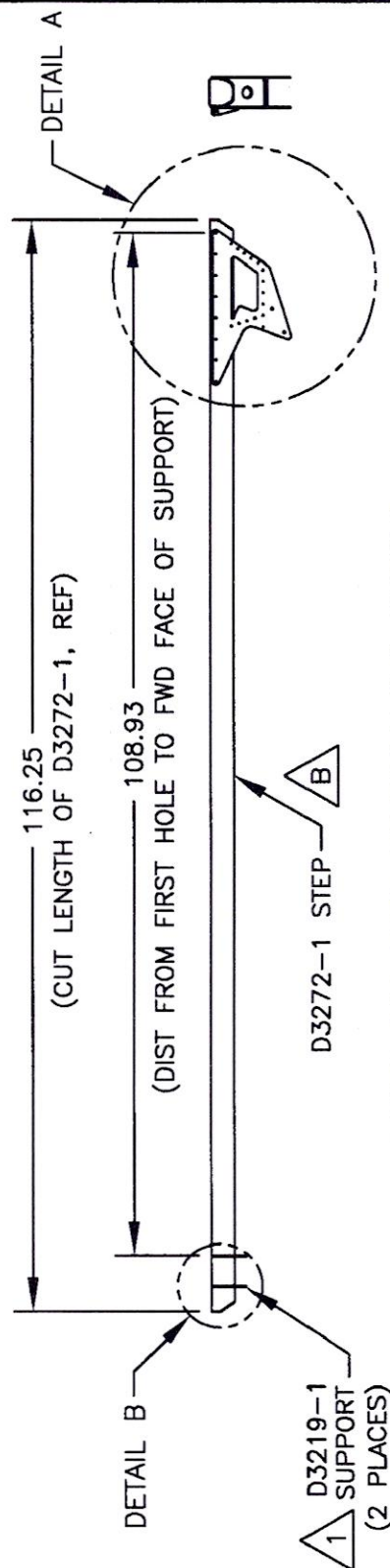
SH
149913
ON
WORK ORDER
WITHOUT NOTICE
SUBJECT TO AMENDMENT
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

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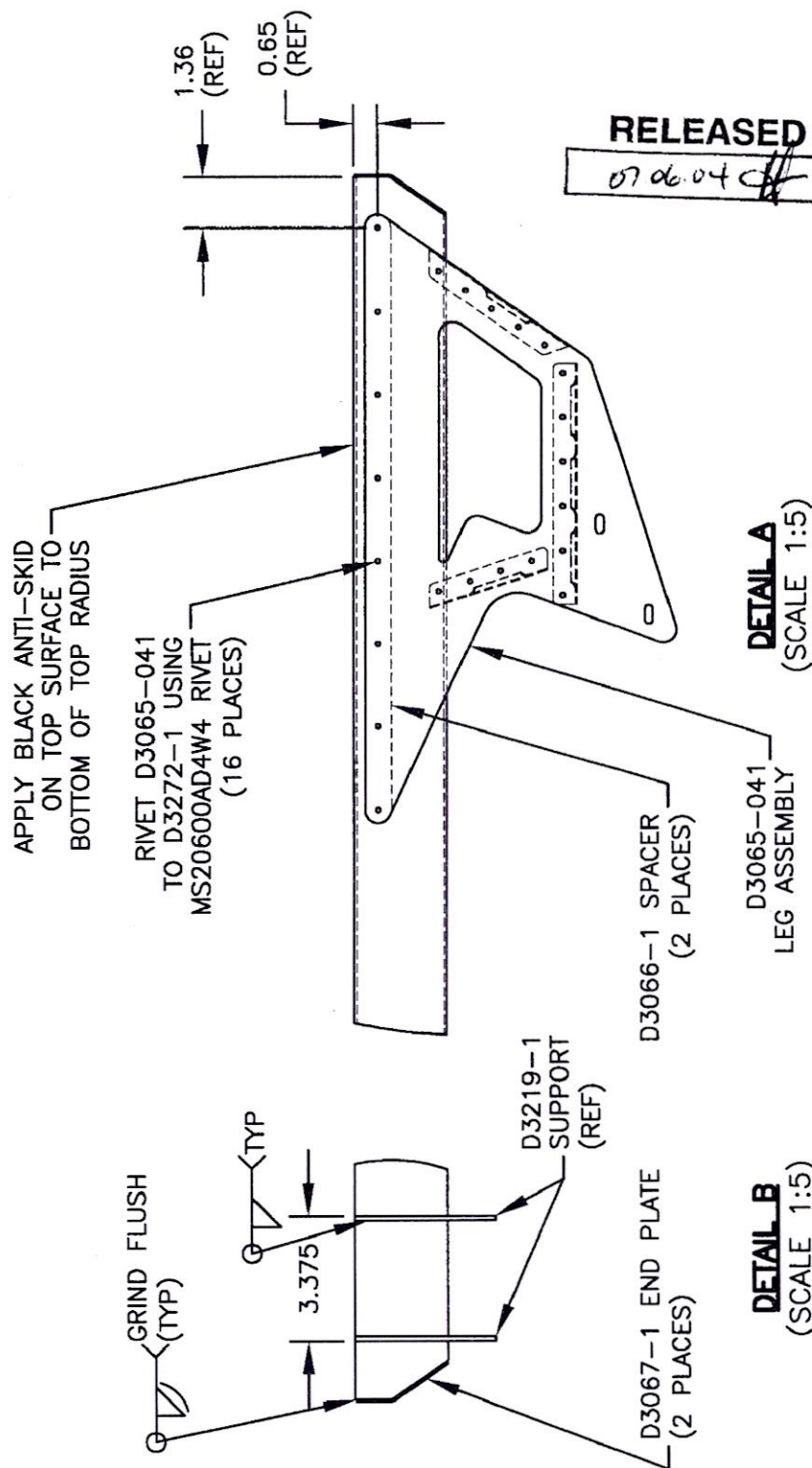
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DESIGN <i>GP</i>	DRAWN BY <i>JS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 2 OF 3
DATE 07.05.18	TITLE STEP ASSEMBLY, HI LONG		SCALE 1:20



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



RELEASED

07.06.04

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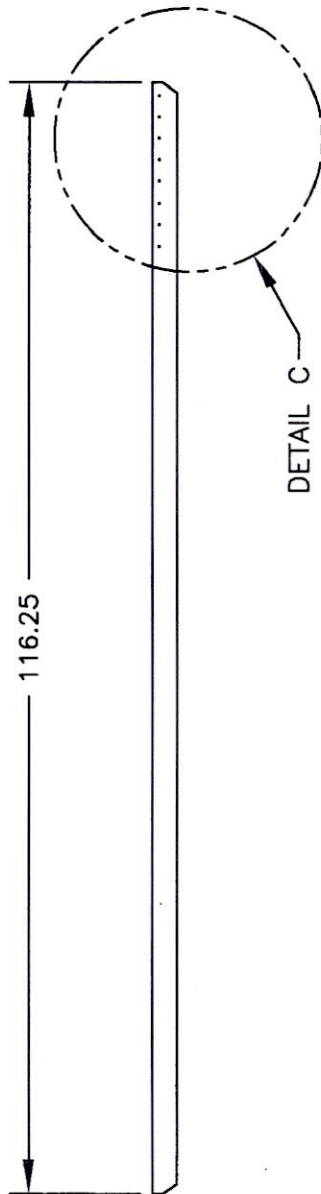
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DESIGN <i>GP</i>	DRAWN BY <i>JB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20

RELEASED

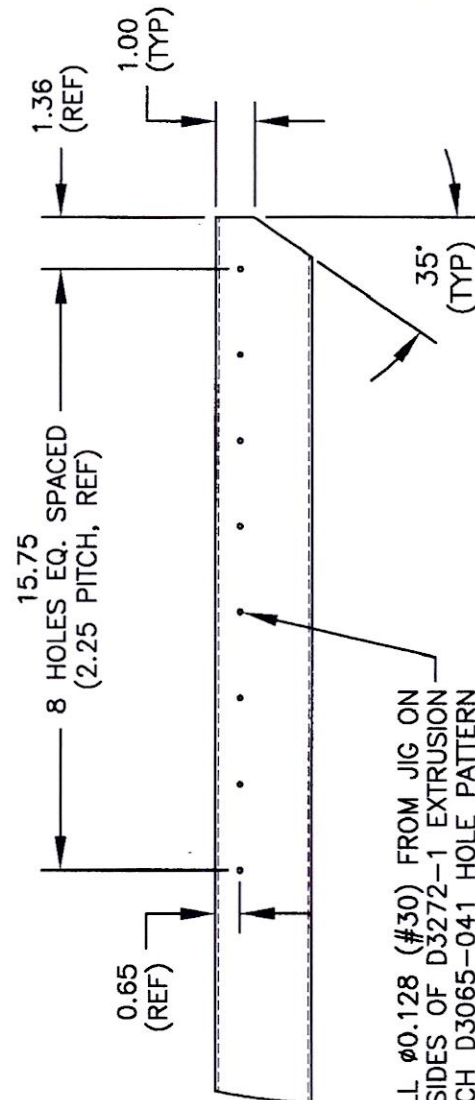
07.06.04 *[Signature]*



DETAIL C

B D3272-1 STEP

(MAKE FROM D2622-120 STEP EXTRUSION)



DRILL $\phi 0.128$ (#30) FROM JIG ON BOTH SIDES OF D3272-1 EXTRUSION TO MATCH D3065-041 HOLE PATTERN

DETAIL C
(SCALE 1:5)

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Work Order ID 149913

August 10, 2016 2:00:45 PM

149913

Page 1

Item ID: D350-591-311

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 8/10/2016 Start Qty: 4.00

4

Cust Item ID:

Required Date: 8/31/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

AUG 08 2016

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3272

Rev B

100

Document Control

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

12
NOW - AIRBUSDAS
21
9-89

SEP 08 2016

110

Large Fab

0.00

110

Large Fab

Memo

0.21

Large Fab

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/RAluminum Rod 134826

3-Grind End Plate flush

4

AUG 31 2016

DAS
24
8-89

Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X						D350-591-213	Heli-Access-Step™, Short Step -- High Skid, LH
	X					D350-591-214	Heli-Access-Step™, Short Step -- High Skid, RH
		X				D350-591-215	Heli-Access-Step™, Short Step -- Low Skid, LH
			X			D350-591-216	Heli-Access-Step™, Short Step -- Low Skid, RH
				X		D350-591-311	Heli-Access-Step™, Long Step -- High Skid, LH
					X	D350-591-312	Heli-Access-Step™, Long Step -- High Skid, RH
1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
				1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
					1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
2	2	2	2	4	4	D2230-3	MOUNTING LUG
2	2	2	2	2	2	D2618	BUSHING
4	4	4	4			D2732-030	CUSHION
				2	2	D2856-400-720	ABRASION STRIP
2	2	2	2	2	2	D3235-1	MOUNTING LUG
				1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	AN3-35A	BOLT
				8	8	AN4-13A	BOLT
4	4	4	4			AN4-15A	BOLT
2	2	2	2	2	2	AN5-36A	BOLT
4	4	4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
12	12	12	12	16	16	NAS1149D0463J	WASHER (AN960JD416)
4	4	4	4	4	4	NAS1149D0563J	WASHER (AN960JD516)
2	2	2	2	2	2	MS21042L3	NUT
6	6	6	6	8	8	MS21042L4	NUT
2	2	2	2	2	2	MS21042L5	NUT
				1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for installation of the DSI 9410-011 Kit.